

Date: Tuesday, 10/02/2009 2:43:31 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	MECHANICAL GROUND HANDLING WHEEL KIT
Job Number :	45681B		
Estimate Number :	12140		
P.O. Number :		Part Number :	D206731042
This Issue :	10/02/2009	Drawing Number :	DSK 093 REV B
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	//	Drawing Revision :	B
Previous Run :	44441B	Material :	
Written By :		Due Date :	28/02/2009
Checked & Approved By :	JLD 09.02.10	Qty:	1 Um: Each
Comment :	est rev. A 01.02.01 new issue EC Est Rev:B As per Rev b 07-02-13 JLM est rev C 07.05.14 rev C IIN ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D33355	spring
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 pick:
 qty Part Number Description batch
 1 D3335-5 spring

2.0	D3353042	Lug Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 pick:
 qty Part Number Description batch
 1 D3353-042 LUG ARM WELDMENT

3.0	D3354042	Mirror Arm Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 pick:
 qty Part Number Description batch
 1 D3354-042 Left Arm Weldment

4.0	D3354043	Right Arm Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 RIGHT ARM WELDMENT
 batch:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 45681B

Part Number: D206731042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D33561

Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	D3356-1	pin	_____

6.0

D3397041

Wheel Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description	batch
2	D3397-041	Wheel ass'y	_____

7.0

113800

GREASE FITTING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	113-800	GREASE FITTING	_____

8.0

656051

flat washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description	batch
2	656-051	flat washer	_____

9.0

663079

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	663-079	Lock washer	_____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Seq. #:	Machine Or Operation:	Description :
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10.0	AN523A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	AN5-23A	Bolt	

11.0	AN960JD516	Washer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	AN960JD516	Washer	

12.0	CP21	1/8" Cotter Pin 2" long
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description	batch
2	CP-21	1/8" Cotter Pin 2" long	

13.0	MS21042L5	Nut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	MS21042L5	Nut	

14.0	SNF34	SLOTTED NUT
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	SNF-34	SLOTTED NUT	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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15.0	TP2	Inventory
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	TP-2	Spring pin	

16.0	TP134	Inventory
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

qty	Part Number	Description	batch
1	TP-134	Spring pin	

17.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Assemble as per dwg DSK 093

2-Grease fitting 113-800, apply LPS C30316 on all parts areas not protected by paint or grease.

18.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

19.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

20.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

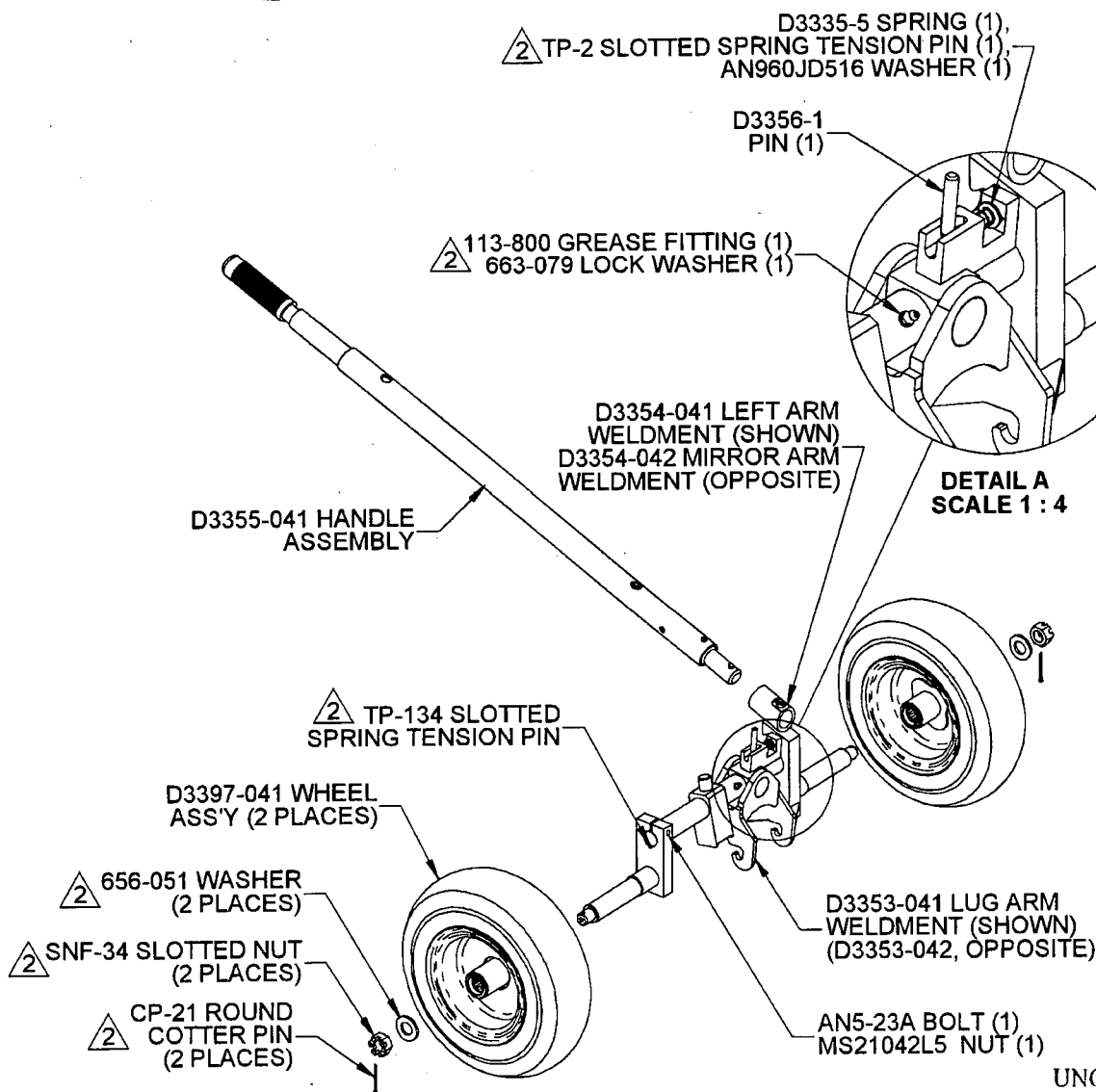
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
07.02.05

DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSK 093	REV. B SHEET 1 OF 1
DATE 07.02.02		TITLE MECH. GROUND HANDLING	SCALE 1:10
REV	DATE	DESCRIPTION	
A	05.02.10	NEW ISSUE	
B	07.02.02	REDRAWN	



D206-731-041, LH MECHANICAL GROUND HANDLING (SHOWN)
D206-731-042, RH MECHANICAL GROUND HANDLING (OPPOSITE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 45601B

NOTE:

- 1) APPLY RUST INHIBITOR ON ALL PARTS AND AREAS NOT PROTECTED BY PAINT OR GREASE.
RUST INHIBITOR POSSIBLE SUPPLIER: ACKLANDS-GRANGER INC., P/N LPSC30316.
- 2) SUPPLIER: SPAENAUER.

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